

dep 18/09

Work Order ID 107038

107038

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September-16-13 11:21:19 AM

Item ID: D4636-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer Plate

Start Date: 9/16/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/18/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 13-09-16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4636

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: C

2-Deburr if necessary

6 0 Ae 13.09.18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 Ae 13.09.18

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

6 0 13.09.18

13.09.18

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Item ID: D4636-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Retainer Plate
 Start Date: 9/16/13 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 9/18/13 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST116</u>	0.00							
130									
Packaging	Memo	0.00				6X	285	13-09-18	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00						13-09-19	
Quality Control									

13-09-18

Picklist Print

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Work Order ID: 107038

Parent Item: D4636-7

Parent Item Name: Retainer Plate

Start Date: 9/16/13

Required Date: 9/18/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC
DWG REV:C DD VERF:JLM

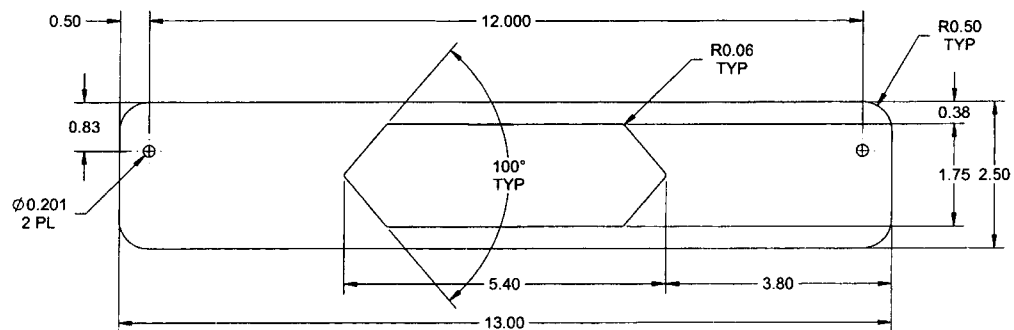
IPP REV:C 13.07.17 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	450.5000	0.0106	0.0669474			

Ac 13.09.18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	450.5	
118271	10.76	
120866	54.87	
121889	64.87	
m126593	320	





126593
~~126511~~ → 0.67



D4636-7 RETAINER PLATE

NOTES:

- 1) MATERIAL: AISI 303 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR ASTM 240 OR ASME SA240
REF DART SPEC M303S22GA
OR AISI 304/316 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM 240 OR ASME SA240
REF DART SPEC M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4636	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2013-07-13


107038MLW
13-09-16

